

Work Order ID 136378

136378

Page 1

Wednesday, September 02, 2015 3:09:09 PM

Item ID: D135-692-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 9/4/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/16/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: SEP 03 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev A1	6 9-89							DAS 02 9-89
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D135-692-011	CHG002							SEP 23 2015
150	Pick Kit	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

2 DAS 6 9-89
 27 9-89
 SEP 21 2015
 SEP 23 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause.		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Work Order ID 136378

Wednesday, September 02, 2015 3:09:09 PM

136378

Page 2

Item ID: D135-692-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 9/4/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/16/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00

170

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D135-692-011

Location:

PPP Rev:

SEP 23 2015

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MW SEP 23 2015

20150923

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

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Page 1

Work Order ID: 136378

136378

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 9/4/2015

Required Date: 9/16/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step
3KJ/JLM IPP REV:E AS PER DSI
9592/9587 REV A JLM VERIFIED BY:EC
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A		Purchased	No				Each	283.0000	8	16			
AN4-13A	DAS 02 9-89								**				DAS 02 9-89
Bolt													DAS 02 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				FG	20								
				122808	20								
				ST344	263								
				m132551	263					16			
D2182B		Manufactured	No			160	f	653.8768	2	4			
D2182B									**				
Rubber Cushion - Black (\$Per Foot)	DAS 02 9-89												DAS 02 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST411	653.8768								
				130427	303.8768					4			
				135093	350								
D2274		Manufactured	No			160	Each	19.0000	8	16			
D2274	DAS 02 9-89								**				
Radius Block													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				FG	12								
				86855	12								
				ST	7								
				110264	7								

DAS
6 SEP 21 2015
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : ☐							

Picklist Print

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Page 2

Work Order ID: 136378

136378

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 9/4/2015

Required Date: 9/16/2015

Start Qty: 2.00

Required Qty: 2.00

D2519

Manufactured No

160

Each

38.0000

4

8

D2519

Clamp

DAS
02
9-89

Location

Loc Qty

Loc Code

ST542

38

101510

6

133908

8

134298

22

99606

2

**

DAS
6
9-89

DAS
27
9-89

D2529

Manufactured No

160

Each

270.0000

8

16

D2529

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

ST007

169

131945

169

ST008

101

128950

1

135846

100

**

DAS
6
9-89
SEP 21 2015
DAS
27
9-89

16

D3049-1

Manufactured No

160

Each

0.0000

2

4

D3049-1

Bearpaw

DAS
02
9-89

**

DAS
6
9-89

DAS
27
9-89

B136457 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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136378

D135-692-011

Start Date: 9/4/2015

Required Date: 9/16/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

160

Each

2,226.000

8

16

MS21042L4

Locknut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

122

m127813

122

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1932

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

1752

NAS1149D0463J

Purchased

No

160

Each

3,234.000

8

16

NAS1149D0463J

DAS
02
9-89

WASHER

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M133077

1000

ST269

2193

M129682

86

M130799

371

M132035

723

M132317

125

M132677

888

DAS
6
9-89

DAS
27
9-89

SEP 21 2015

DAS
27
9-89

DAS
6
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Shop Packet Print

Page 3

DQA: _____ Date: _____



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Start Date: 9/4/2015

Required Date: 9/16/2015

Start Qty: 2.00

Required Qty: 2.00

QS100-M24S

Purchased

No

160

Each

20.0000

4

8

QS100-M24S

Clamp

M13234 x4

SEP 21 2015

**DAS
02
9-89**

Location

Loc Qty

Loc Code

ST544

20

m132342

20

4

**DAS
6
9-89**

**DAS
27
9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

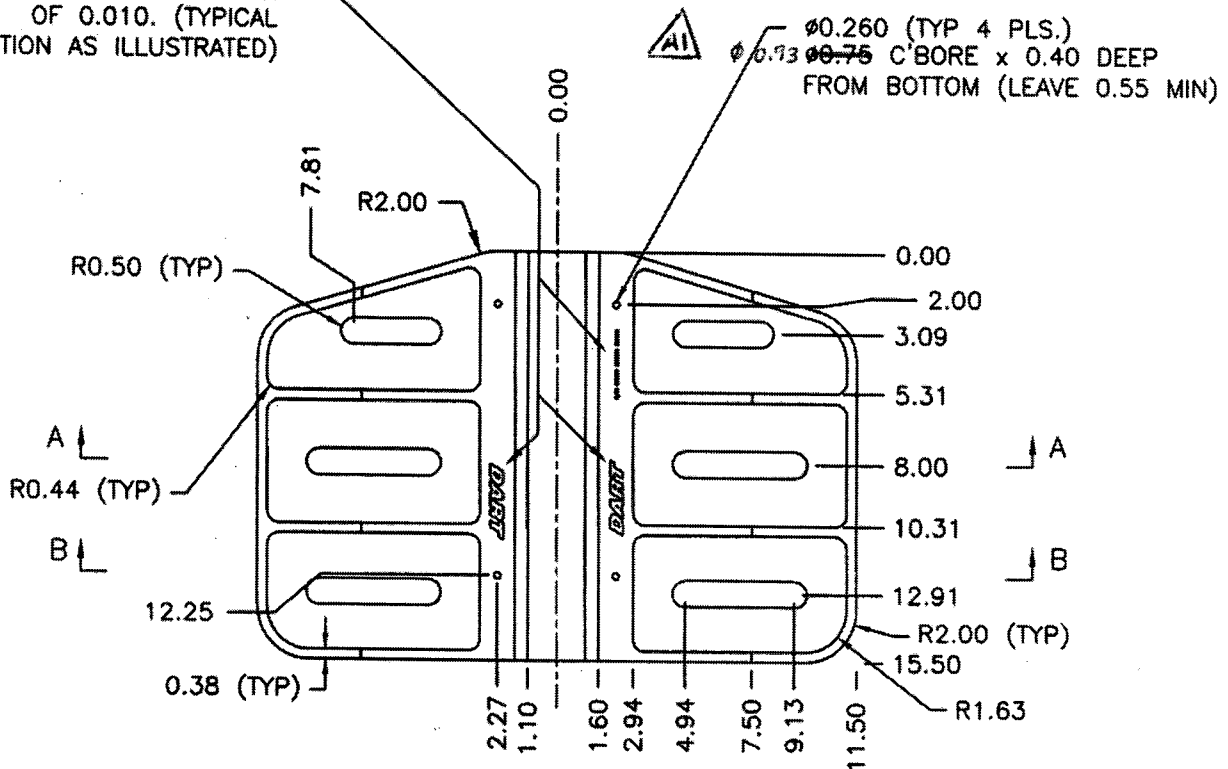
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18	TITLE BEARPAW		SCALE 1:1
A	01.10.18	NEW ISSUE	
AI	# RF 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

136378-ML5
150903
SUPER COPY
RETURN TO
ENGINEERING
FOR AMENDMENT
NOTICE
136378-ML5
150903

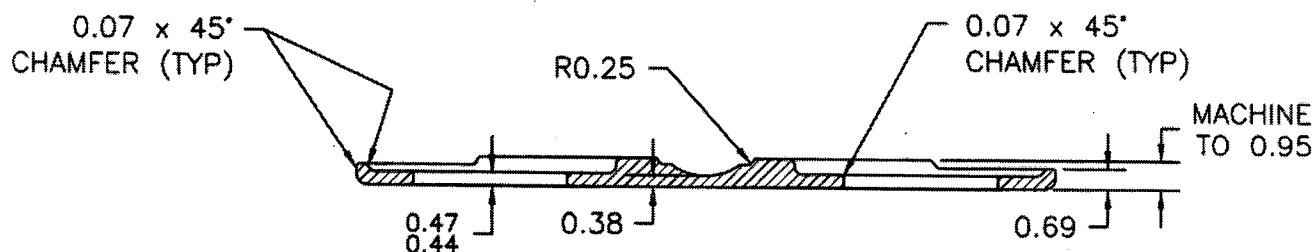
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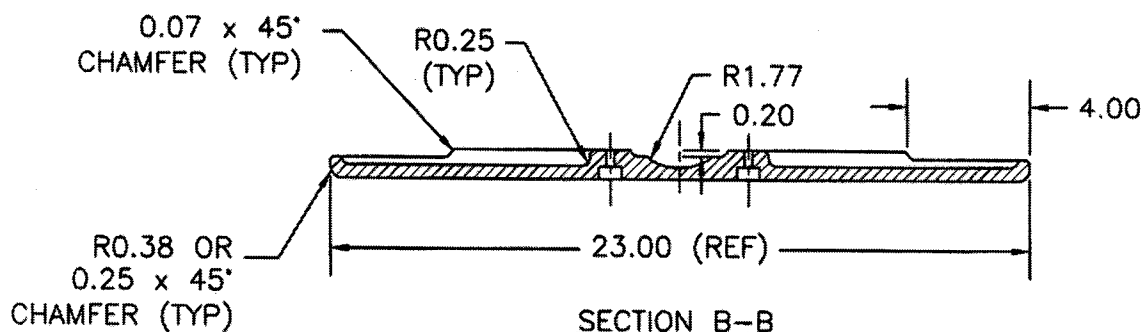


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24



SECTION A-A



SECTION B-B

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4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 <i>Bearpaw Installation</i>	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg
D135-692-041 <i>Wearplate Kit</i>	2.24 lb 1.0 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	199.7 in 5.07 m	447 in-lb 5.1 m-kg
D135-692-011 <i>Bearpaw Installation, Aft Location</i>	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	201 in 5.10 m	2372 in-lb 27.3 m-kg
D135-692-041 <i>Wearplate Kit, Aft Location</i>	2.24 lb 1.0 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	201 in 5.10 m	450 in-lb 5.1 m-kg

5. PARTS LIST

Qty -011	Qty -041	Part Number	Description
X		D135-692-011	BEARPAW INSTALLATION
	X	D135-692-041	WEARPLATE KIT
4		D2182B060	RUBBER CUSHION
8		D2274	RADIUS BLOCK
2		D3049-1	BEARPAW
8		D2529	WASHER
4		D2519	CLAMP
	2	D3719-041	WEARPLATE
8	8	AN4-13A	BOLT
8	8	NAS1149D0463J	WASHERS
8	8	MS21042L4	NUT (OR MS21042-4)
4		QS100M24S	CLAMP